

NCR-19-7690



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3278-3

Job Sheet 200097



Part No: D3278-3

Job Qty: 50 pcs

Part Name: Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/6/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP . A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	50 pcs	10/4/19	10/4/19	0.01	0.97	Waterjet - Flow	10/3/19	JRB
		50 pcs	10/4/19	10/4/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - 2 - B4B	50 pcs	10/4/19	10/4/19	0.00	0.88	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		

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CANADA
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Container No: S219416

Part: D3278-3

Job No: 200097

Serial No/Batch: S219416

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/03/19

DAS
40
9-89

OCT 17 2019

DAS
58
9-89

OCT 07 2019

140 QC 5	50 pcs	10/4/19	0.00 0.00	Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	50 pcs	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	50 pcs	10/4/19	0.00 0.00	QC 21 - SA - 21	

DAS
40

OCT 09 2019 3:00

DAS

OCT 07 2019 3:00

DAS

11

DAS

21 OCT 10 2019

3:00

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 120 - (QC8- Inspect parts - second check)
 Descriptions: 130 - (Small Fab)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - Identify as per dwg & Stock Location: **GA 117**
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRINS0.125	Black Delrin Sheet .125	1.7200 sf (.0344 ea)	100-Waterjet - Flow - 1	SI 37107

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	MDELRINS0.125	2	36	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	1.980inches ± 0.030	2.010 1.950		
2	Spacer	1.980inches ± 0.030	2.010 1.950		
3	Spacer	1.480inches ± 0.005	1.485 1.475		
4	Spacer	0.250inches ± 0.010	0.260 0.240		
5	Spacer	1.480inches ± 0.005	1.485 1.475		
6	Spacer	0.250inches ± 0.010	0.260 0.240		
7	Spacer	0.098inches + 0.005 - 0.000	0.103 0.098		
8	Spacer	0.130inches ± 0.030	0.160 0.100		
9	Spacer	0.125inches ± 0.010	0.135 0.115		

Plex 9/6/19 1:04 PM Dart.lajeunesse.marie

Entered: 78 Date: Nov 1/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7690

Route update only ☐

Job: <u>280097</u> Part No. <u>D3278-3</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐																														
Date: <u>OCT 09 2019</u>		Sequence #: <u>140</u>		QTY Affected: <u>360 F48 11</u>		MRR (QSI042) DAS 51 9-89 <u>14/10/19</u>																												
Description Work Order Deviation				Disposition		Completed By OCT 09 2019 DAS 40 9-89																												
-counter sink are too big -drawing 0,188 -actual parts 0,259				-Scrap		Lead hand / Supervisor DAS 30 9-89 <u>OCT 18 2019</u>																												
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☒ Off-set/Set-up</td> <td></td> </tr> </table>			☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☒ Off-set/Set-up	
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Other/Details: <u>Counter sink too big 0,188 is 0,258</u>				QC / QA Coordinator <u>19-10-09</u>																														